

AMENDMENTS TO THE CLAIMS

Claims 1-2 (Canceled)

Claim 3 (Previously Presented): A process for manufacturing a hot-rolled sheet made of iron/carbon/manganese steel, in which:

- a semifinished product is smelted and cast from a steel whose chemical composition comprises, the contents being expressed by weight:

$$0.5\% \leq C \leq 0.7\%$$

$$17\% \leq Mn \leq 24\%$$

$$Si \leq 3\%$$

$$Al \leq 0.050\%$$

$$S \leq 0.030\%$$

$$P \leq 0.080\%$$

$$N \leq 0.1\%,$$

and, optionally, one or more elements such that:

$$Cr \leq 1\%$$

$$Mo \leq 0.40\%$$

$$Ni \leq 1\%$$

$$Cu \leq 5\%$$

$$Ti \leq 0.50\%$$

$$Nb \leq 0.50\%$$

$$V \leq 0.50\%,$$

the composition further comprising iron and inevitable impurities resulting from the smelting;

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- said semifinished product of said steel composition is heated to a temperature of between 1100 and 1300°C;
- said semifinished product is rolled with an end-of-rolling temperature of 890°C or higher;
- a delay is observed between said end of rolling and a subsequent rapid cooling operation, in such a way that the point defined by said delay and said end-of-rolling temperature lies within an area defined by the ABCD'E'F'A plot of figure 1; and
- said sheet is coiled at a temperature below 580°C.

Claim 4 (Original): The process as claimed in claim 3, wherein said semifinished product is cast in the form of thin strip, by being cast between steel rolls.

Claim 5 (Previously Presented): The manufacturing process as claimed in claim 3, wherein, after said coiling, said hot-rolled sheet is subjected to a cold deformation operation with an equivalent deformation ratio of 30% or less.

Claim 6 (Canceled)

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Claim 7 (Previously Presented): A process for manufacturing a cold-rolled austenitic iron/carbon/manganese steel sheet, wherein:

- a hot-rolled sheet obtained by the process as claimed in claim 3 is subjected to at least one cold-rolling followed by an annealing operation, each cold-rolling comprising:
  - cold-rolling said sheet and
  - carrying out an annealing operation at a temperature of between 600 and 900°C for a time of between 10 and 500 seconds, followed by a cooling operation, the cooling rate being greater than 0.5°C/s,
- the austenitic grain size, before the final cold-rolling step followed by an annealing operation, being less than 18 microns.

Claim 8 (Original): The process for manufacturing a cold-rolled sheet as claimed in claim 7, wherein, after the final annealing, a cold-deformation operation is carried out with an equivalent deformation ratio of 30% or less.

Claims 9-12 (Canceled)

Claim 13 (Previously Presented): A process as claimed in Claim 3, in which:  
a delay is observed between said end of rolling and a subsequent rapid cooling operation, in such a way that the point defined by said delay and said end-of-rolling temperature lies within an area defined by the ABCDEFA plot of figure 1.